

Work Order ID 110137

110137

Page 1

December-17-13 9:15:55 AM

Item ID: D4092-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step Assembly
 Start Date: 12/17/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 13-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4092	B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4X DAS 28 9-89 14-01-23

4X DAS 36 9-89 14/01/29

DAS 27 9-89

14/1/29

4

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Item ID: D4092-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step Assembly

Start Date: 12/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

ST 270

0.00

Packaging

14/01/28 (4)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-02-04

(H) 14-01-30

Picklist Print

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Work Order ID: 110137
 Parent Item: D4092-042
 Parent Item Name: Maintenance Step Assembly

Start Date: 12/17/13
 Start Qty: 4.00

Required Date: 12/17/13
 Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD
 639 JLM VERIFIED BY:DD
 IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No				Each	5.0000		8		DAS 28 9-89	14-01-23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST270		5				B110087 (7x)			
				108408		3				1x			
				74303		1							
				77852		1							
D4093-1 Bracket		Manufactured	No				Each	10.0000		4		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST270		10							
				108191		3							
				108292		7				4x			
D4093-3 Bracket		Manufactured	No				Each	9.0000		4		DAS 28 9-89	14/01/29
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST270		9							
				102880		1							
				109476		8				4x			B110076 (4x)
D4093-5 Bracket		Manufactured	No				Each	14.0000		8		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST092		10							
				109411		10				4x			
				ST270		4							
				108405		4							

Picklist Print

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Work Order ID: 110137
 Parent Item: D4092-042
 Parent Item Name: Maintenance Step Assembly

Start Date: 12/17/13
 Start Qty: 4.00

Required Date: 12/17/13
 Required Qty: 4.00

MS24694-S54	Purchased	No	Each	388.0000	8	DAS	14-01-23
SCREW						28	
						9-89	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		ST303	388				
		125535	388		8X		
MS24694-S55	Purchased	No	Each	197.0000	32	DAS	
Screw						28	
						9-89	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		ST303	197				
		m127305	97		32X		
		m127327	100				
MS24694-S56	Purchased	No	Each	117.0000	8	DAS	
SCREW						28	
						9-89	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		ST303	117				
		121340	10				
		125535	7		8X		
		m126400	100				
NAS1149D0332J	Purchased	No	Each	2,579.0000	48	DAS	
Washer						28	
						9-89	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
		ST293	964				
		m127374	70				
		m127431	894				
		ST294	215				
		122973	57				
		m125807	158				
		ST510a	1400				
		m127374	400		48X		
		m127389	1000				

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 110137

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

Each

6,342.0000

48

DAS

28

9-89

14-01-23

Nut

Location

Loc Qty

Loc Code

GA

194

M126333

194

ST314

28

M126036

28

ST506

793

123900

793

ST509

4000

M127304

1000

M127410

3000

ST510a

1327

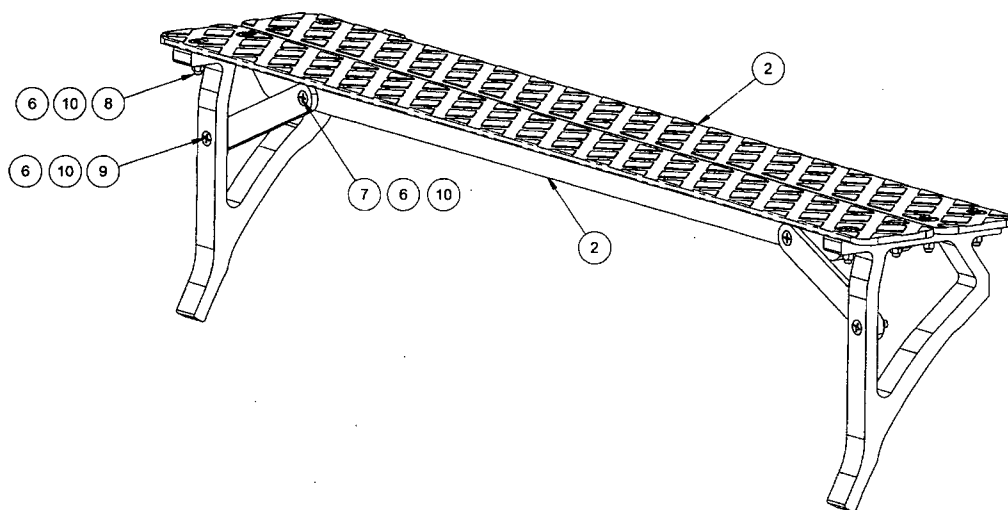
M126275

8

M126333

1319

127831



D4092-041 MAINTENANCE STEP ASSEMBLY

B

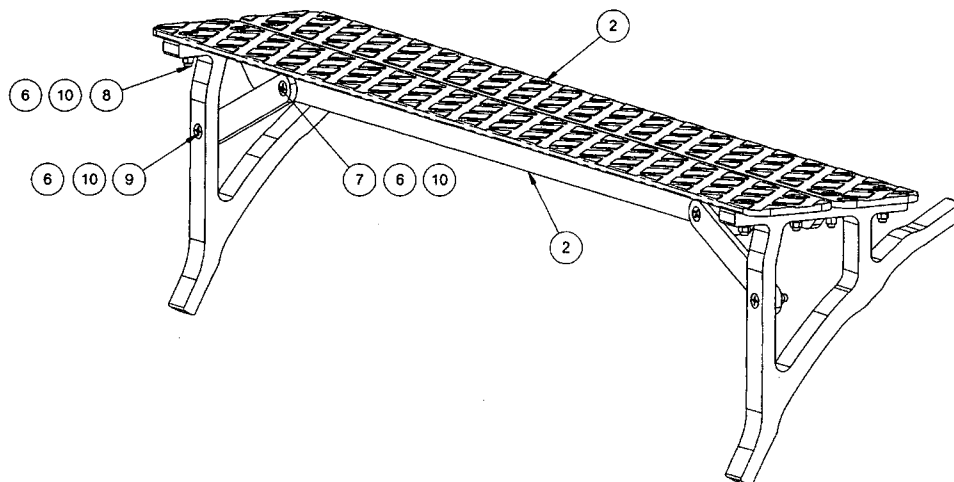
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

110137 MCT
13-12-19

RELEASED
2011-09-22

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

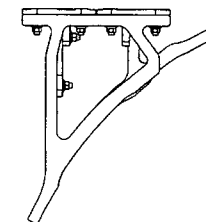
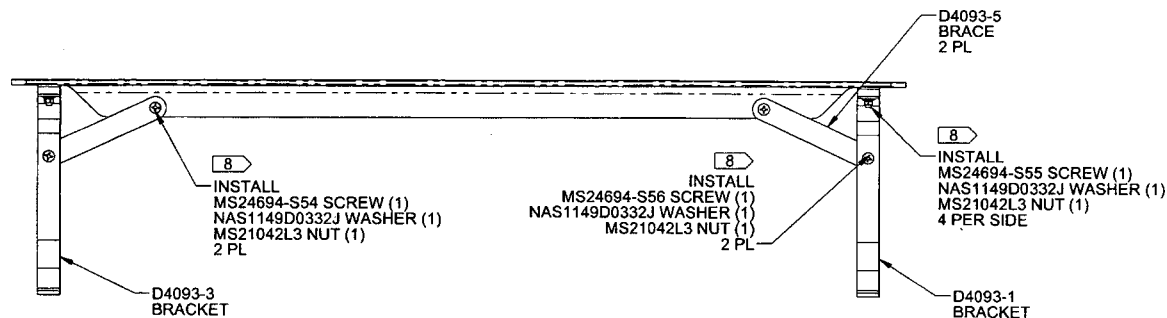
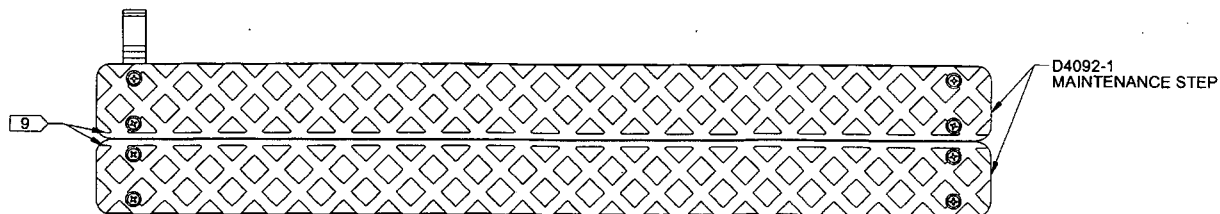


D4092-042 MAINTENANCE STEP ASSEMBLY



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2011-09-23
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MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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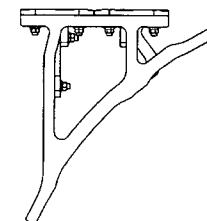
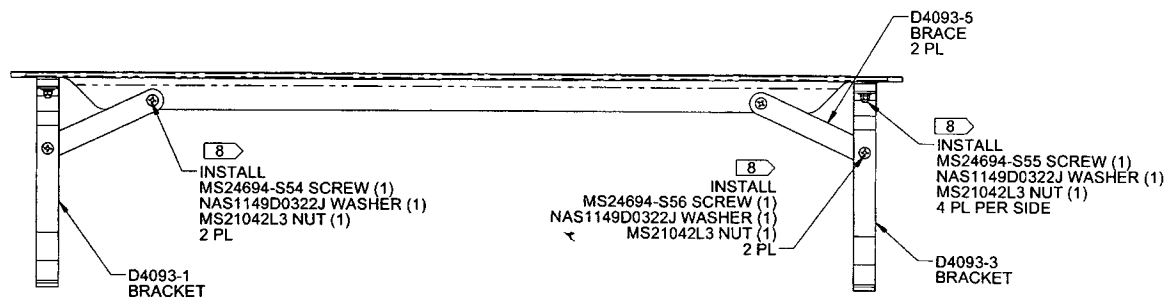
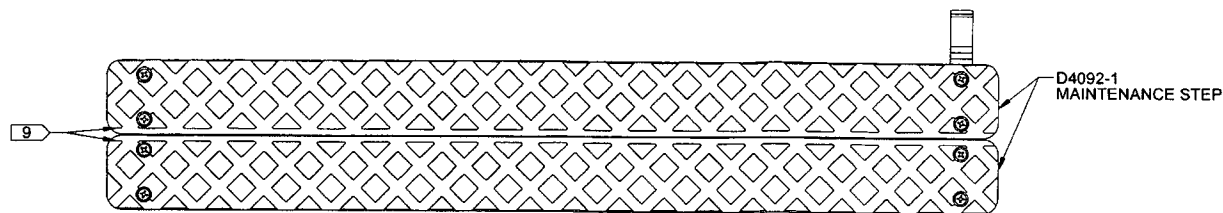
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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MFG. APPR.	<i>AT</i>	D4092	SHEET 3 OF 6
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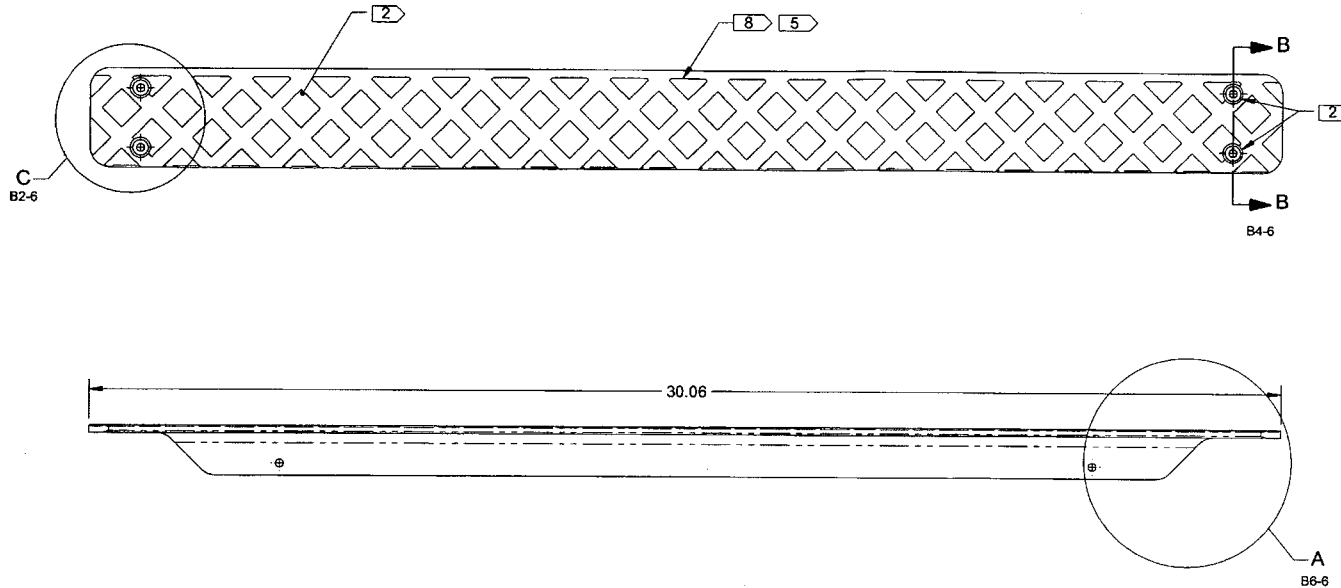
D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>91</i>	D4092	SHEET 4 OF 6
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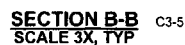
D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

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2011-09-22
JWW

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 5 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
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MFG. APPR.	<i>RF</i>	D4092	SHEET 6 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	
DATE	11.07.27	NTS	

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